

## 03–440 Static balancing of flywheel

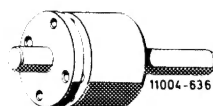
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### Data

| Flywheel for           | Balance bores<br>max. drilling depth | Drill dia. | Hole locating dia. |
|------------------------|--------------------------------------|------------|--------------------|
| manual transmission    | 20 + 1                               | 11         | 251                |
| automatic transmission | drilled through                      |            |                    |

### Special tool

Balancing mandrel  
(flywheel for automatic and  
manual transmissions)



617 589 00 63 00

### Conventional tool

Rolling device for static  
balancing

Trebel, D-4030 Ratingen  
type EO, order no. 03600/0904/E 0010

### Note

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Crankshaft, balance disc and flywheel are balanced together.

A new flywheel must be balanced to the same value of the one removed.

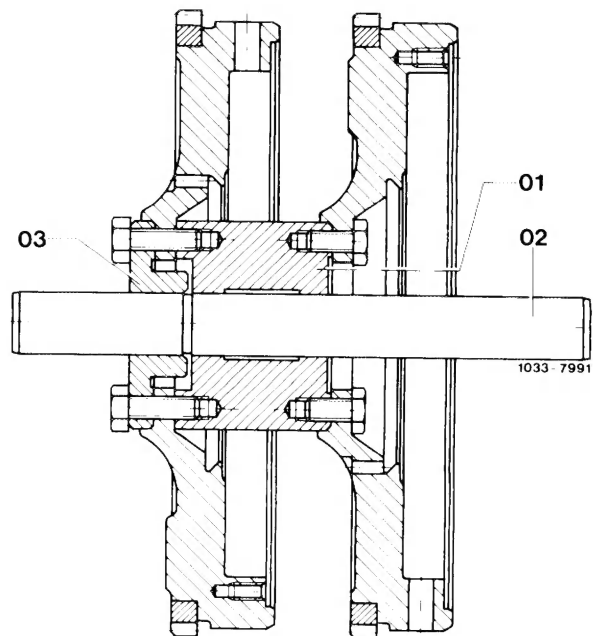
The balancing condition of a flywheel for manual transmission can be transferred to a flywheel for automatic transmission by static balancing (and vice versa).

### Static balancing

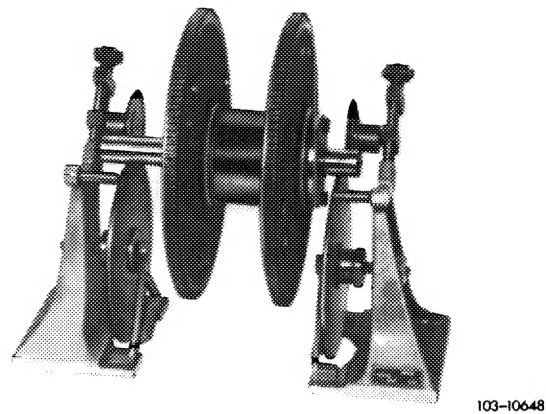
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- 1 Place old and new flywheels on top of each other that all bores align and both clutch surfaces face in one direction.
- 2 Transfer mark from old to new flywheel.

3 Apply balancing mandrel and bolt new flywheel with an offset of exactly  $180^\circ$  over old unit.



4 Let balancing mandrel with both flywheels oscillate on rolling device.



5 If an unbalance is found, drill so many holes in mass of new flywheel until the flywheels remain still without oscillating in any position.

**Attention!**

The hole circle dia, the drill dia and the max drilling depth must be maintained (refer to table).

The dust bores (arrows) must not be drilled.

